

Work Order ID 71224

Friday, June 24, 2011 11:20:41 AM



Page 1

Item ID: D3442-1

Revision ID:

Item Name: Shim

Start Date: 6/24/2011 Start Qty: 12.00

Required Date: 6/30/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:



Date: 1104-24 Tooling:

Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Date:

Setup Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3442

Rev B: 1104-23

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304 .032

1-Cut as per Dwg D3442

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-6-27

(7)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

0.00

Subtotal

B11-6-27

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71224

Friday, June 24, 2011 11:20:41 AM



Page 2

Item ID: D3442-1

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Small Fab

Memo

Deburr if necessary.

N
A.

0.00

MF
11-06-28

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Packaging

Identify as per dwg & Stock Location

3/C

0.00

Packaging

Memo

*****STOCK IN BASKET CELL*****

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71224

Friday, June 24, 2011 11:20:41 AM



Page 3

Item ID: D3442-1

Accept



Setup

Start



Revision ID:

Item Name: Shim

Stop



Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

16/28 JJ

Memo

0.00

MF

16-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 24, 2011 11:20:45 AM

Page 1

Work Order ID: 71224



Parent Item: D3442-1



Parent Item Name: Shim

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A□05.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	53.5600	0.04	0.505263	7		 B11-6-07

304/316 .032 Sheet

Location	Loc Qty	Loc Code
020	7	
109057	7	
MAT020	46.56	
117379	46.56	

109057

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	71224
Description: Shim	Part Number:	D3442-1
Inspection Dwg: D3442	Rev: A B 02 11-06-24	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>1-6-27</u>	Date: <u>1/6/27</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

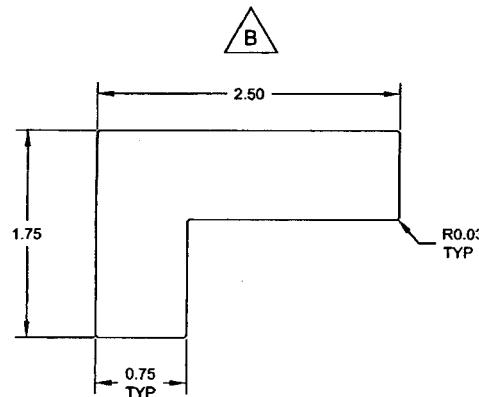
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

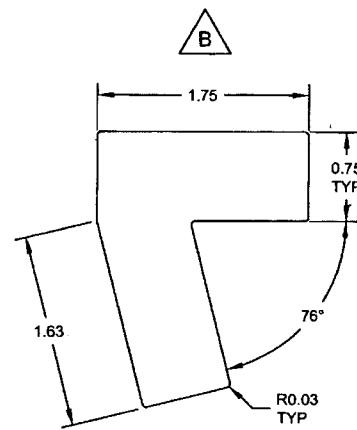
8 7 6 5 4 3 2 1

D

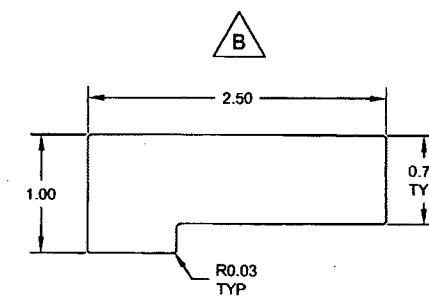
D



D3442-1 SHIM



D3442-3 SHIM



D3442-5 SHIM

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 71224

PH 11-06-20

RELEASED
2011-05-30
WP

NOTES:

1) MATERIAL D3442-1/-3: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
22 GAUGE (0.031 THICK)
REF. DART SPEC. M304S22GA

D3442-5: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
16 GAUGE (0.063 THICK)
REF. DART SPEC. M304S16GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.03 lbs APPROX



B	REFORMAT. MATERIAL FOR -1 & -3 WAS 21 GAUGE. TOLERANCE UPDATED FOR ALL PARTS. (SEE PAR 10-005)	AJS	11.05.26
A	NEW ISSUE	PH	05.06.03
REV.	DESCRIPTION		
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED	<i>JK</i>	D3442	SHEET 1 OF 1
MFG. APPR.	<i>EE</i>	APPROVED	SCALE
DE APPR.	<i>JK</i>	SHIM	NTS
DATE	11.05.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries